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General Specifications

The Wilton Model 8014 Vertical Band Saw is a multi-purpose metal cutting band saw that will suit almost any metal working application. Typical applications include contour sawing, beveling, slicing ripping, and stack cutting. The variable speed saw has a tilting table and a useful speed and pitch selector.

An optional blade welder, mounted on the saw, provides a means to quickly weld and anneal new or broken saw blades. The welder includes a blade shear and weld grinder.

Specifications

Vertical Band Saw

Model Number	8014
Cutting Capacity	6-1/16 inches (1-170 mm)
Throat Depth	14-3/16 inches (360 mm)
Table Size	19-1/2 by 21-1/4 inches
Blade Width	1/8-inch to 1/2-inch (2-13 mm)
Length of Saw Blade	106 to 110-1/2 inches
Belt Stepless Variable Speed	98 to 394 feet per minute (30-120 m/min)
Main Motor	1 hp
Table Tilt	
Right	45 degrees
Left	15 degrees
Front/Back	10 degrees
Height of Table	35-7/16 inches (900 mm)
Dimensions	
Height	63 inches (1600 mm)
Depth	38-3/16 inches (970 mm)
Width	22-13/16 inches (580 mm)
Net Weight	709 pounds

Optional Welder

Model	8000
Electrical Rating	2 kva
Grinding Motor	1/8 hp

⚠ WARNING

- Misuse of this machine can cause serious injury.
- For safety, machine must be set up, used and serviced properly.
- Read, understand and follow instructions in the Operating Instructions and Parts Manual which was shipped with your machine.

When Setting up Machine:

- Always avoid using machine in damp or poorly lighted work areas.
- Always be sure the machine support is securely anchored to the floor or the work bench.

When Using Machine:

- Always wear safety glasses with side shields (See ANSI Z87.1)
- Never wear loose clothing or jewelry.
- Never overreach - you may slip and fall.

When Servicing Machine:

- Always disconnect the machine from its electrical supply while servicing.
- Always follow instructions in Operating Instructions and Parts Manual when changing accessory tools or parts.
- Never modify the machine without consulting Wilton Corporation.

You - the Stationary Power Tool User - Hold the Key to Safety.

Read and follow these simple rules for best results and full benefits from your machine. Used properly, Wilton's machinery is among the best in design and safety. However, any machine used improperly can be rendered inefficient and unsafe. It is absolutely mandatory that those who use our products be properly trained in how to use them correctly. They should read and understand the Operating Instructions and Parts Manual as well as all labels affixed to the machine. Failure in following all of these warnings can cause serious injuries.

Machinery General Safety Warnings

1. Always wear protective eye wear when operating machinery. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specifications. Use of eye wear which does not comply with ANSI Z87.1 specifications could result in severe injury from breakage of eye protection.
2. Wear proper apparel. No loose clothing or jewelry which can get caught in moving parts. Rubber soled footwear is recommended for best footing.
3. Do not overreach. Failure to maintain proper working position can cause you to fall into the machine or cause your clothing to get caught pulling you into the machine.
4. Keep guards in place and in proper working order. Do not operate the machine with guards removed.
5. Avoid dangerous working environments. Do not use stationary machine tools in wet or damp locations. Keep work areas clean and well lit.
6. Avoid accidental starts by being sure the start switch is OFF before plugging in the machine.
7. Never leave the machine running while unattended. Machine shall be shut off whenever it is not in operation.
8. Disconnect electrical power before servicing. Whenever changing accessories or general maintenance is done on the machine, electrical power to the machine must be disconnected before work is done.
9. Maintain all machine tools with care. Follow all maintenance instructions for lubricating and the changing of accessories. No attempt shall be made to modify or have makeshift repairs done to the machine. This not only voids the warranty but also renders the machine unsafe.
10. Machinery must be anchored to the floor.
11. Secure work. Use clamps or a vise to hold work, when practical. It is safer than using your hands and it frees both hands to operate the machine.
12. Never brush away chips while the machine is in operation.
13. Keep work area clean. Cluttered areas invite accidents.
14. Remove adjusting keys and wrenches before turning machine on.
15. Use the right tool. Don't force a tool or attachment to do a job it was not designed for.
16. Use only recommended accessories and follow manufacturers instructions pertaining to them.
17. Keep hands in sight and clear of all moving parts

and cutting surfaces.

18. All visitors should be kept at a safe distance from the work area. Make workshop completely safe by using padlocks, master switches, or by removing starter keys.
19. Know the tool you are using, its application, limitations, and potential hazards.

General Electrical Cautions

This saw should be grounded in accordance with the National Electrical Code and local codes and ordinances. This work should be done by a qualified electrician. The saw should be grounded to protect the user from electrical shock.

Wire Sizes

Caution: For circuits which are far away from the electrical service box, the wire size must be increased in order to deliver ample voltage to the motor. To minimize power losses and to prevent motor overheating and burnout, the use of wire sizes for branch circuits or electrical extension cords according to the following table is recommended.

Conductor Length	AWG (American wire gauge) Number	
	240 Volt Lines	120 Volt Lines
0 - 50 Feet	No. 14	No. 14
50 - 100 Feet	No. 14	No. 12
Over 100 Feet	No. 14	No. 8

Safety instructions on sawing systems

1. Always wear leather gloves when handling saw blade. The operator shall not wear gloves when operating the machine.
2. All doors shall be closed, all panels replaced, and other safety guards in place prior to the machine being started or operated.
3. Be sure that the blade is not in contact with the workpiece when the motor is started. The motor shall be started and you should allow the saw to come up to full speed before bringing the saw blade into contact with the workpiece.
4. Keep hands away from the blade area. **See Figure A.**
5. Remove any cut off piece carefully while keeping your hands free of the blade area.
6. Saw must be stopped and electrical supply must be cut off before any blade replacement or adjustment of blade support mechanism is done, or before any attempt is made to change the drive belts or before any periodic serve or maintenance is performed on the saw.
7. Remove all loose items and any unnecessary workpieces from the area before starting machine.
8. Bring adjustable saw guides and guards as close as possible to the workpiece.
9. Always wear protective eye wear when operating, servicing, or adjusting machinery. Eyewear shall be impact resistant, protective safety glasses with side shields complying with ANSI Z87.1 specifications. Use of eye wear which does not comply with ANSI Z87.1 specifications could result in severe injury from breakage of eye protection. **See Figure B.**
10. Nonslip footwear and safety shoes are recommended. **See Figure C.**
11. Wear ear protectors (plugs or muffs) during extended periods of operation. **See Figure D.**
12. The workpiece, or part being sawed, must be securely clamped before the saw blade enters the workpiece.
13. Remove cut off pieces carefully, keeping hands away from saw blade.
14. Saw must be stopped and electrical supply cut off or machine unplugged before reaching into cutting area.
15. Avoid contact with coolant, especially guarding your eyes.

A

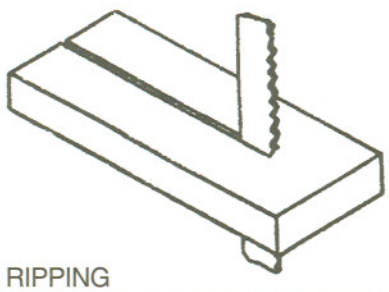
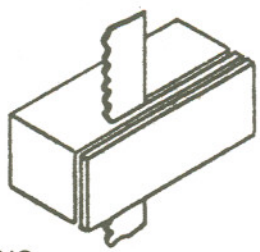
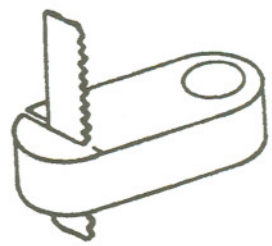
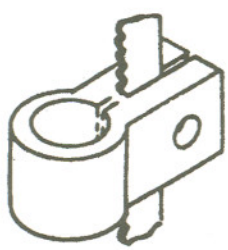
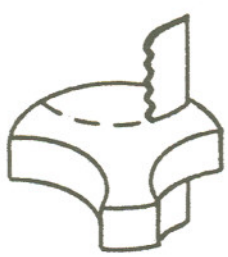
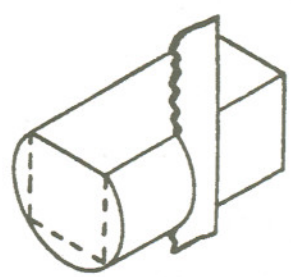
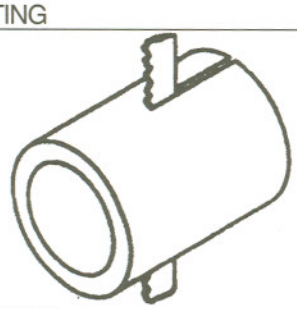
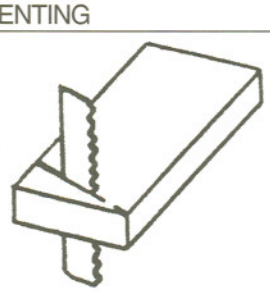
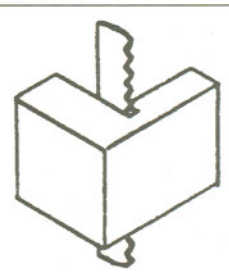
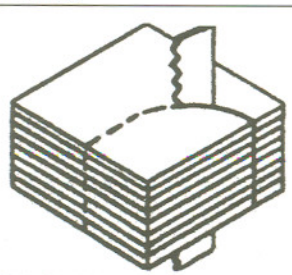
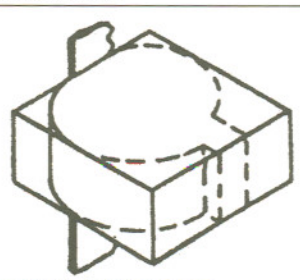
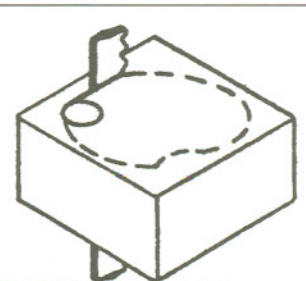
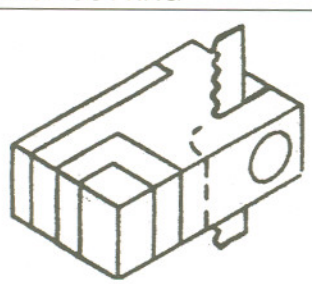
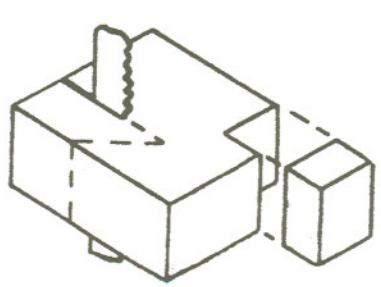
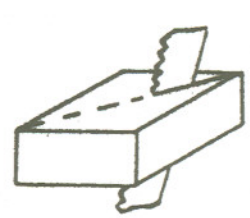
B

C

D

Introduction

This manual includes the operating and maintenance instructions for the Wilton 14-inch Vertical Band Saw, Model 8014. This manual also includes parts listings and illustrations of replaceable parts. Typical operations performed using the band saw are shown below.

 RIPPING	 SLICING	 BEVELING
 SLOTTING	 SEGMENTING	 SHAPING CUT
 SPLITTING	 ANGULAR CUT	 GRINDING RELIEF
 STACK CUTTING	 EXTERNAL CONTOUR	 INTERNAL CONTOUR
 THREE-DIM. CUTTING	 SHAPING	 COMPOUND ANGLE CUT

Saw Features

Refer to Figure 1 for key features of the 14-Inch Vari-Speed Vertical Band Saw.

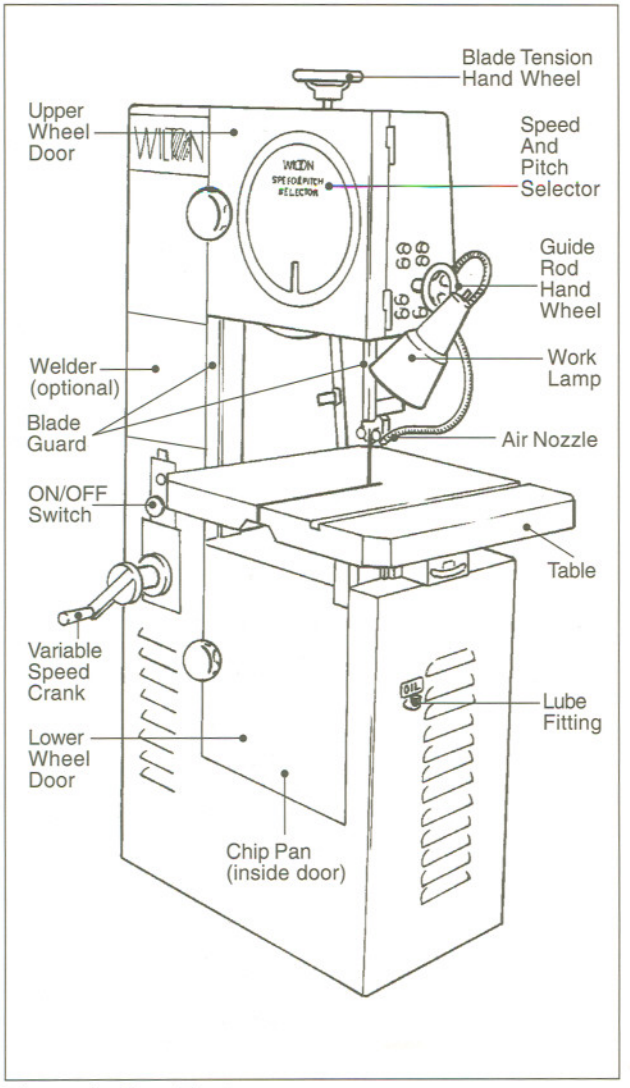


Figure 1: Saw Features

Setup and Operation

Installation

The frame of the vertical band saw has four mounting holes in the base of the saw frame. The band saw may be secured to the floor using the four mounting holes.

Electrical Connection

Refer to the Wiring Diagram section for wiring information. Connection to electrical power should be made by a qualified electrician.

Operating Instructions

Controls (Refer to Figure 2)

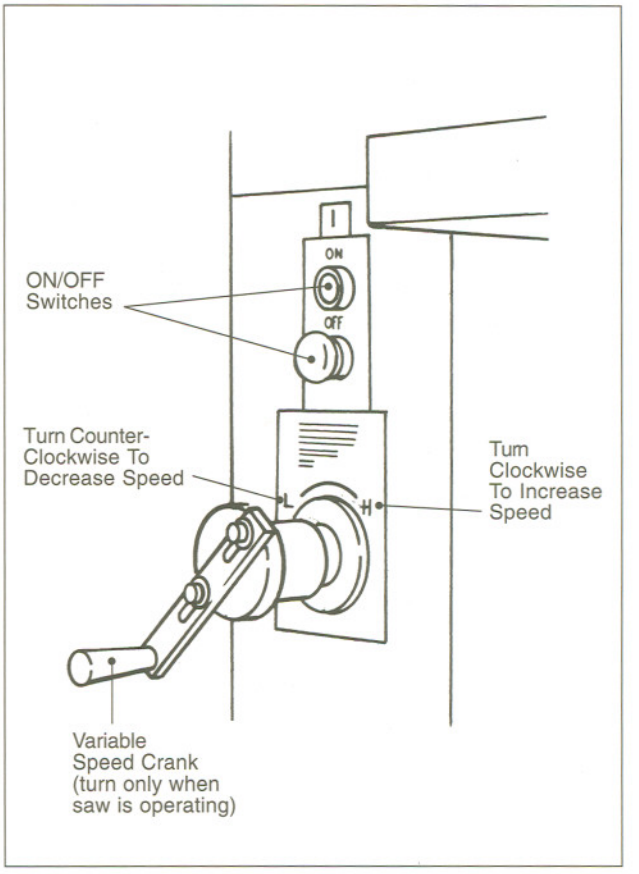


Figure 2: Operating Controls

The operating controls for the saw are located on the left side of the machine. The controls include the following:

1. A set of start/stop push buttons, located below the optional welder, provide a means to start and stop the saw drive motor.
2. A variable speed control (crank), which can only be adjusted while the saw is running, is located below the start/stop buttons.
3. A blade tensioning hand wheel is mounted on the top of the saw enclosure.
4. Refer to **Optional Blade Welder** for a description of the welder controls.

Optional Blade Welder

An optional blade welder is available on the Model 8014 vertical band saw. The welder has all the features required to cut, weld, and anneal the saw blade.

Welder Features
(Refer to Figure 3)

The welder is installed on the left side of the saw frame. A blade cutter, provided with the welder, is mounted on the saw frame near the panel.

The welder has two clamps that are used to clamp and hold the ends of the saw blade during welding. The welder controls include a clamp pressure selector, welding and annealing pushbutton switches, and switches for the blade grinder and welder light.

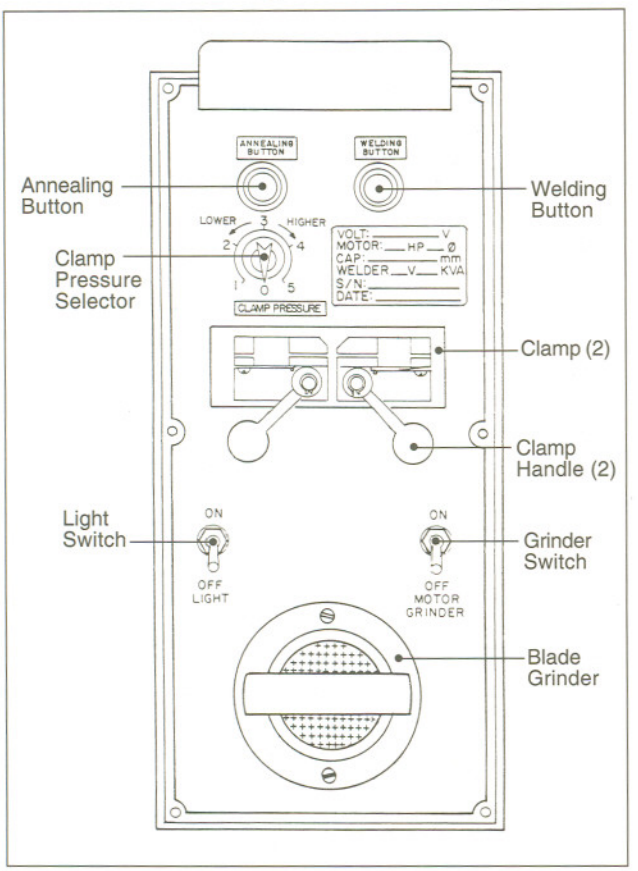


Figure 3: Welder Features

Operating the Welder
(refer to Figure 4)

<u>WARNING</u>: BE SURE TO WEAR EYE PROTECTION WHILE OPERATING THE WELDER TO AVOID EYE INJURIES. USE CARE WHEN HANDLING THE BLADE AFTER WELDING TO AVOID BURNS.

1. Using the blade cutter, cut the blade to the required length (View A).
2. Using the blade grinder, square-off the blade ends (View B). The blade ends need to be perpendicular to the side of the blade. The blade ends must be square so there is minimal gap between the ends when clamped f or welding.
3. Insert one end of the blade in the left clamp (View C). Position the back edge of the blade against the back of the left clamp. Then position the end of the blade midway between the left and right clamps. Tighten the left clamp.
4. Insert the other end of the blade in the right clamp. Position the back edge of the blade against the back of the right clamp. Then butt the end of the blade up against the other end of the blade (the blade ends need to be in contact with each other). Tighten the right clamp.
5. Set the clamp pressure selector switch (clockwise rotation) to the setting required for the width of the blade being welded (see the table on the next page).

<u>NOTE</u>: There will be some resistance when turning the switch.

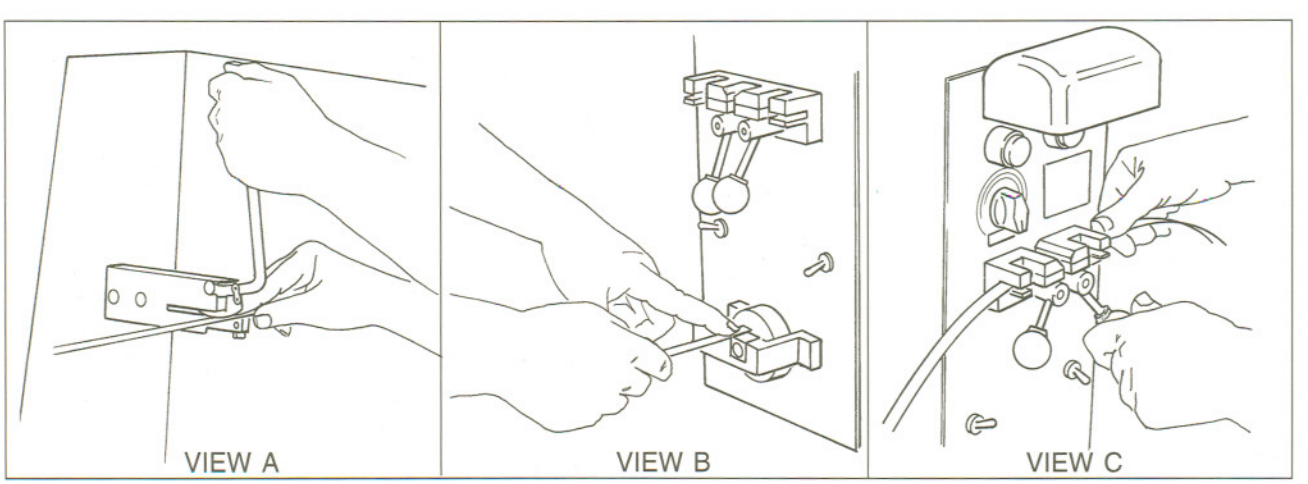


Figure 4: Operating the Welder

Blade Width	Clamp Pressure Selector Setting
1/8" to 1/4"	1
5/16" to 3/8"	2
1/2"	3
5/8"	4
3/4"	5

6. Press and hold the weld pushbutton. When the pusbutton is pressed, the right clamp moves to the left to apply pressure to the blade ends. At the same time, there will be sparking from the blade ends as the blade is being welded.
7. Release the weld push button and unclamp the left and right clamps.
8. Rotate the clamp pressure switch (clockwise) to the zero position.
9. Center the weld between the two clamps. Tighten the clamps.
10. The weld is hard and brittle and must be annealed before use. To anneal the weld, quickly depress and release (jog) the anneal pushbutton. Repeat the depress and release process until you see a red glow (slightly red) from the weld area.

CAUTION: DO NOT PRESS AND HOLD THE ANNEAL PUSHBUTTON. THE WELD WILL BE OVERHEATED AND THE WELD WILL FAIL DUE TO THE EXCESSIVE HEAT.

11. Release both blade clamps and remove the blade.
12. Check the integrity of the weld. Bend the blade to form a radius in the blade at the point of the weld. The size of the radius should be approximately the same as the radius of the saw drive wheel. The weld must hold and not break or crack after forming the radius. If the weld breaks, cut away the welded area and repeat the welding/annealing process.

CAUTION: CHECK THE BLADE TO MAKE SURE THE WELDED SECTION IS THE SAME THICKNESS AS THE REST OF THE BLADE. IF THE BLADE IS THICKER AT THE WELD, THE BLADE GUIDES MAY BE DAMAGED.

13. Check to make sure the welded section is the same thickness as the rest of the blade. If not, grind off excess weld material using the grinder on the welder.

Setting Blade Speed

WARNING: NEVER OPERATE THE SAW WITHOUT BLADE COVERS IN PLACE AND SECURED.

CAUTION: DO NOT TURN SPEED SETTING CRANK UNLESS THE SAW MOTOR IS OPERATING. THE SPEED SETTING MECHANISM CAN BE DAMAGED.

1. Start the saw using the start pushbutton.
2. Refer to the Speed and Pitch selector on the left side of the saw enclosure. Select the speed setting for the material to be cut.
3. Turn the speed setting crank to the required speed. Turning the crank to the right (clockwise) increases speed. Turning the crank to the left (counterclockwise) decreases speed.

Blade Selection

The vertical band saw is equipped with a Wilton part number 9108381 saw blade that is adequate for a variety of common materials. The blade is a 10-tooth, 1/2-inch multi-purpose blade. (Refer to the speed and pitch indicator on the left side of the vertical saw to select the blade and speed required for various materials.)

A coarse blade is generally used for a solid steel bar but a finer tooth blade used on a thin-wall tube. In general, the blade choice is determined by the thickness of the material; the thinner the material, the finer the tooth pitch.

For very high production on cutting of special materials, or to cut hard-to-cut materials such as stainless steel, tool steel, or titanium, contact your industrial distributor for more specific blade recommendations. Also, the supplier who provides the workpiece material should be prepared to provide you with very specific instructions regarding the best blade for the material and shape supplied.

Setting Blade Guide Support

(Refer to Figure 5)

The blade guide support must be adjusted for the thickness of the material to be cut. Adjust the position of the support as follows:

1. Loosen the blade guide support by turning the handwheel on the front of the saw enclosure.
2. Place the material to be cut adjacent to the blade guide. Move the blade guide support by hand until there is clearance between the material to be cut and the blade guide.
3. Tighten the handwheel.

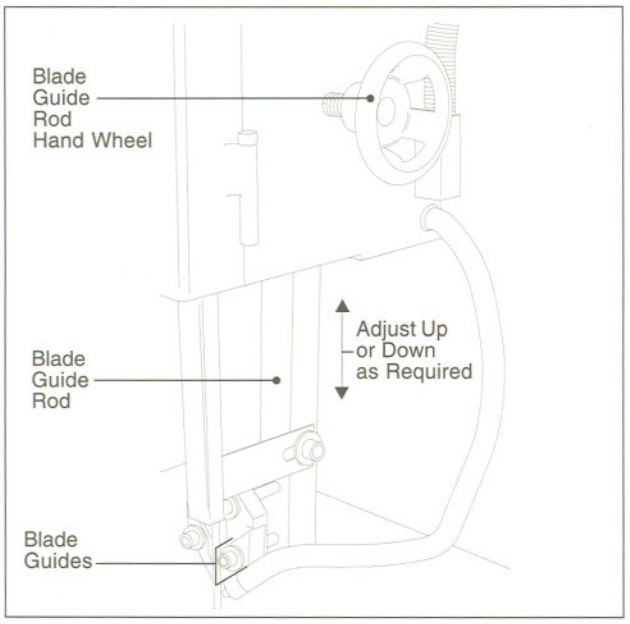


Figure 5: Setting Blade Guide Support

Maintenance

Cleaning

WARNING: DISCONNECT ELECTRICAL POWER TO AVOID POTENTIAL FOR UNINTENDED START-UP DURING MAINTENANCE.PERIODICALLY EMPTY THE CHIP PAN (INSIDE THE LOWER DOOR ON THE LEFT SIDE OF THE MACHINE). USE A BRUSH TO LOOSEN ACCUMULATED CHIPS AND DEBRIS. USE A VACUUM CLEANING TO REMOVE ACCUMULATED DEBRIS.

Lubrication

Bearings: The bearings used in vertical band saw are pre-lubricated, sealed bearings and require no additional lubrication.

Air Pump: Lubricate the air pump every six months. Add oil through the oil fitting on the front of the band saw.

Changing Saw Blades

(Refer to Figure 6)

WARNING: DISCONNECT ELECTRICAL POWER TO AVOID POTENTIAL FOR UNINTENDED START-UP DURING MAINTENANCE.

Follow the procedures below to change the saw blade:

1. Open upper and lower doors on the left side of the band saw.
2. Remove the front and rear blade guards.

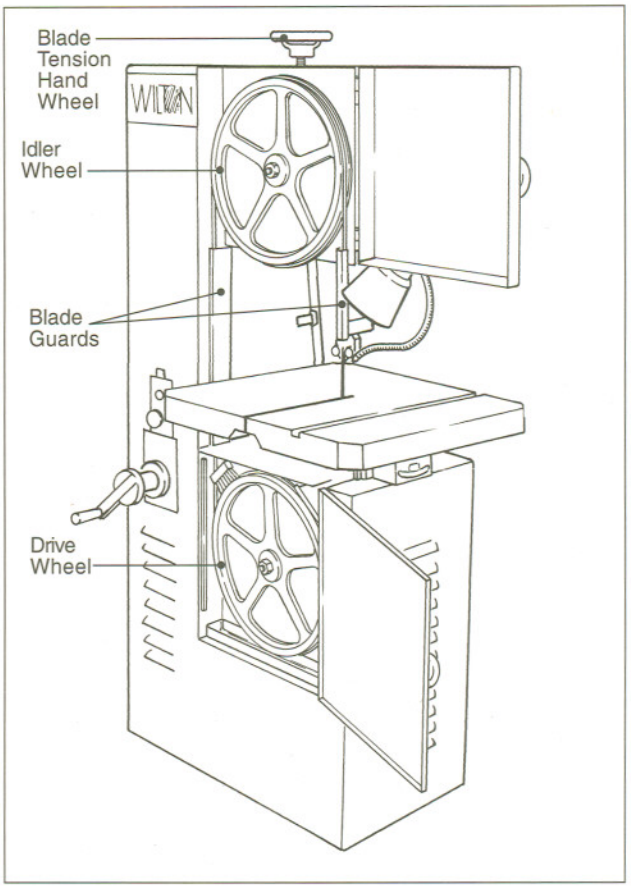


Figure 6: Replacing Saw Blade

3. Release tension on the saw blade by turning the blade tension hand wheel on the top of the band saw.

WARNING: HANDLE THE SAW BLADE WITH GLOVES TO AVOID INJURY.

4. Remove the worn blade and install the new blade. Install the blade so the teeth facing downward where the blade passes through the worktable.
5. Using the handwheel on the top of the saw, tighten the blade.
6. Install the front and rear blade guards.
7. Close the access doors and start the saw.
8. Observe the tracking of the blade. Refer to Adjusting Blade Tracking if the blade does not track properly.

Changing Saw Wheel Drive Belts (Refer to Figure 7)

WARNING: DISCONNECT ELECTRICAL POWER TO AVOID POTENTIAL FOR UNINTENDED START-UP DURING MAINTENANCE

Follow the procedures below to change the drive belt:

1. Open door on the right side of the band saw.

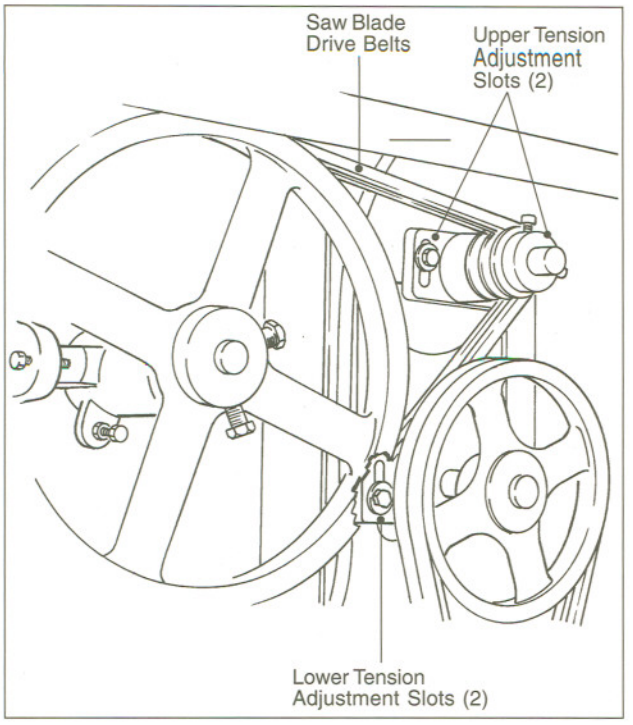


Figure 7: Changing Saw Wheel Drive Belt

2. Loosen bolts on the upper idler pulley support. Slide upper idler pulley support to release tension on belts.
3. Remove worn belts and install new belts.
4. Slide upper idler pulley support to apply tension on belts. Tighten bolts on upper idler pulley support.
5. Close access door.
6. Check operation of the band saw.

Changing Drive Motor/Air Pump Belts **(Refer to Figure 8)**

WARNING: DISCONNECT ELECTRICAL POWER TO AVOID POTENTIAL FOR UNINTENDED START-UP DURING MAINTENANCE

Follow the procedures below to change the drive motor and air pump belts:

1. Open door on the right side of the band saw.
2. Loosen bolts on upper idler pulley support. Slide upper idler pulley support to release tension on belts. Do not remove the saw wheel drive belts.
3. Loosen bolts on lower idler pulley support. Slide lower idler pulley support to release tension on belts.
4. Remove worn motor drive belt. Then remove the air pump drive belt. Install new belts as required.

NOTE: It may be necessary to loosen the drive motor attaching screws to have sufficient slack to remove the air pump drive belt.

5. Slide lower idler pulley support to apply tension on belts. Tighten bolts on lower idler pulley support.

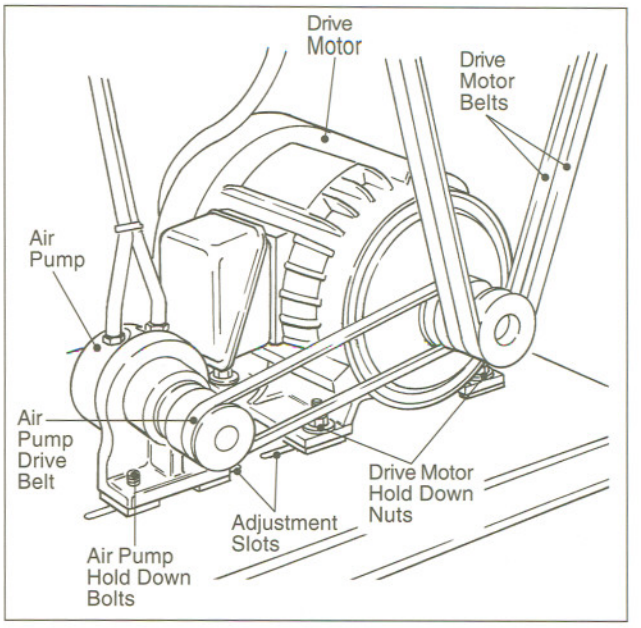


Figure 8: Changing Drive Motor/Air Pump Belts

6. Slide upper idler pulley support to apply tension on belts. Tighten bolts on upper idler pulley support.
7. Close access door.
8. Check operation of the band saw.

Changing Vari-Speed Drive Belt **(Refer to Exploded View, Page 20)**

WARNING: DISCONNECT ELECTRICAL POWER TO AVOID POTENTIAL FOR UNINTENDED START-UP DURING MAINTENANCE

Follow the procedures below to change the vari-speed drive belt:

1. Remove saw wheel and drive motor belts (refer to **Changing Saw Wheel Drive Belts** and **Changing Drive Motor and Air Pump Belt).**
2. Remove lower drive pulley (ref. #58) from lower shaft (ref. #56).
3. Remove upper drive pulley (ref. #63) from upper shaft (ref. #64).
4. Remove upper and lower drive pulley supports (ref. #55).
5. Remove and lower vari-speed mechanisms.
6. Remove worn vari-speed drive belt.
7. Install newvari-speed drive belt.
8. Install the vari-speed mechanism.
9. Install the upper and lower drive wheel supports (ref. #55).
10. Install upper drive pulley (ref. #63) and lower drive pulley (ref. #58).
11. Install drive motor and saw wheel drive belts (refer to **Changing Saw Wheel Drive Belts** and **Changing Drive Motor and Air Pump Belt).**
12. Check operation of the band saw.

Replacement of Blade Guides
(Refer to Figure 9)

1. When removing upper blade guides, remove blade guard from guide support.
2. When removing lower blade guides, open lower left door to access the blade guides (the lower blade guard is attached to the lower door).
3. Remove cap screws and washers from both blade guides.
4. Remove blade guides.
5. Install new blade and secure with cap screws and washers.
6. Adjust blade guides so they just touch the side of the saw blade. Adjust position of guide seat so it just touches the back edge of the blade.

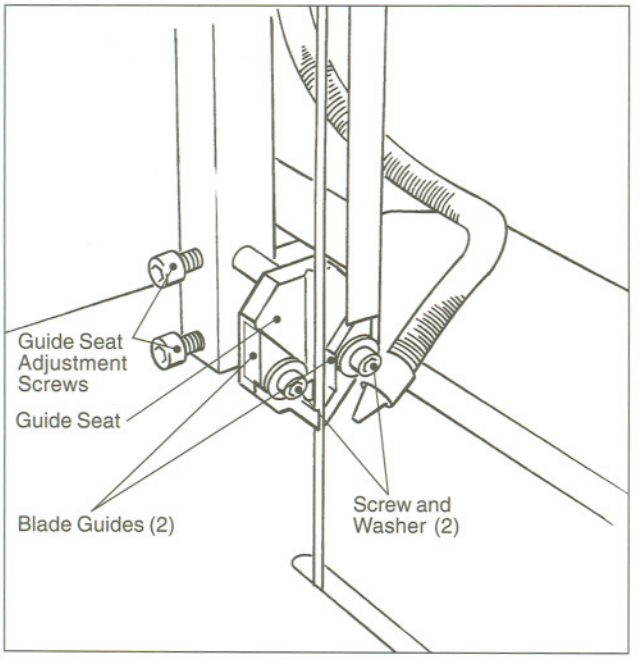


Figure 9: Replacement of Blade Guides

Adjustments
Work Table

The position work table can be adjusted to tilt either left or right (approximately 10 degrees in either direction) The work table can also be adjsuted to tilt approximately 45 degrees to the rear and 15 degrees to the front).

Front/Back **(Refer to Figure 10):**

Loosen hex nut and tilt table to the desired position. Tighten hex nut.

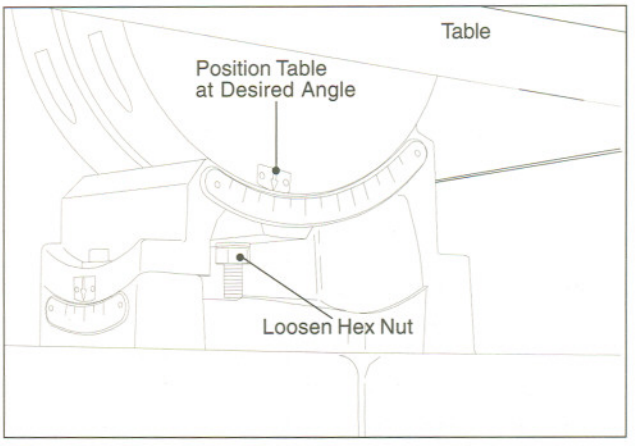


Figure 10: Table Adjustment (Front/Back)

Right/Left **(Refer to Figure 11):**

Loosen two screws. Using the adjustment knob, tilt the table to the desired position. Tighten two screws.

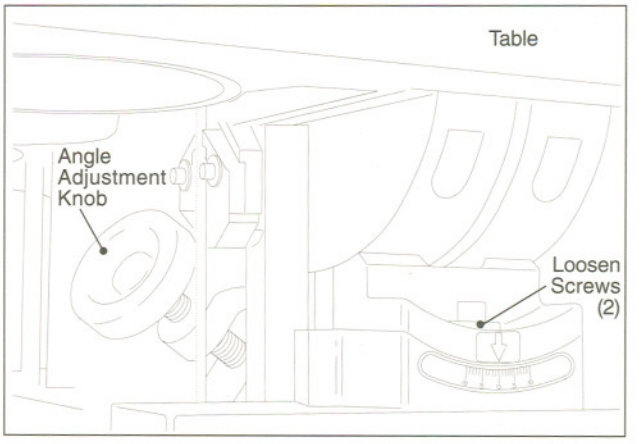


Figure 11: Table Adjustment (Right/Left)

Blade Tracking (Refer to Figure 12)

WARNING: DISCONNECT ELECTRICAL POWER TO AVOID POTENTIAL FOR UNINTENDED START-UP DURING MAINTENANCE

Blade tracking can be corrected using the following procedure

1. Operate the saw to determine if the blade is tracking off center. Determine if the blade is tracking to the right or to the left.
2. To adjust tracking, open the door on the right side of the machine. Loosen the jam nuts on the tracking adjustment screws.
3. If the blade tracks to the right, the bottom of the blade drive pulley (ref. #3) needs to be move outward. Adjust the upper screw outward. Then adjust the lower screw inward. Tighten the upper screw against its stop. Tighten the jam nuts.
4. If the blade tracks to the left, the bottom of the blade drive pulley (ref. #3) needs to be move inward. Adjust the lower screw outward. Then adjust the upper screw inward. Tighten the lower screw against its stop. Tighten the jam nuts.

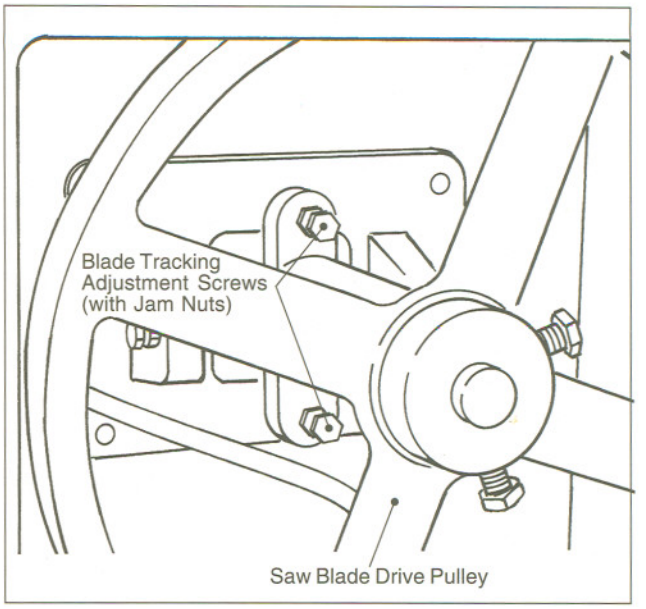


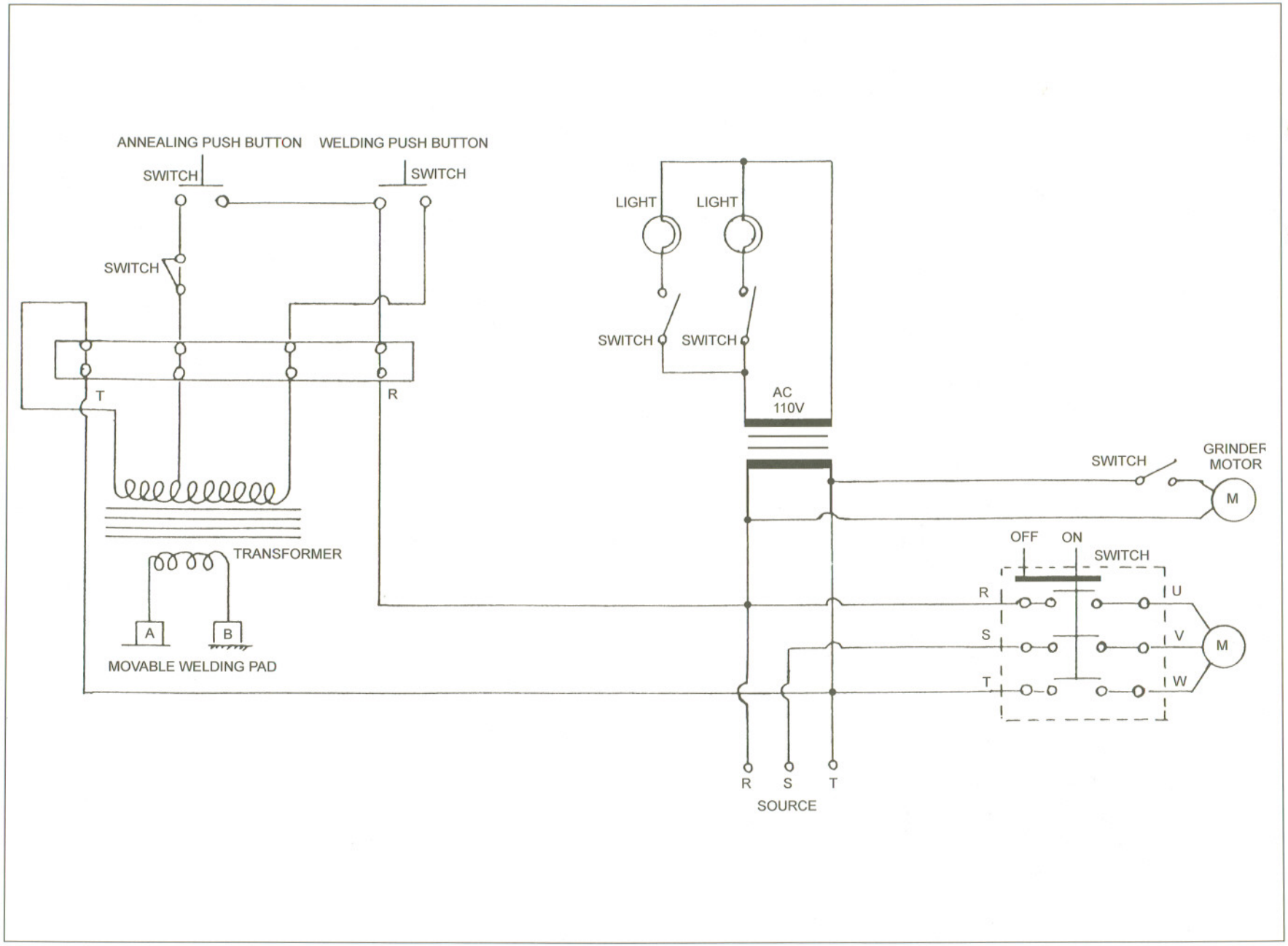
Figure 12: Adjusting Blade Tracking

5. Close the door and operate the saw. Repeat the steps above as required to achieve proper tracking.

Troubleshooting

Fault	Probable Cause	Suggested Remedy
Excessive blade breakage	1. Incorrect speed.	1. Check Machinist's Handbook for speed appropriate for thematerial being cut.
	2. Teeth too coarse for material.	2. Check Machinist's handbook for recommended blade type.
	3. Misaligned guides.	3. Adjust guides.
	4. Cracking at weld	4. Longer annealing cycle.
Premature blade dulling	1. Blade teeth too coarse.	1. Use a finer tooth blade.
	2. Blade speed too high.	2. Reduce blade speed.
Unusual wear on side of blade	1. Blade guides worn.	1. Replace blade guides.
	2. Blade guides not adjusted.	2. Adjust blade guides.
Teeth missing/ripped from blade	1. Blade tooth pitch too coarse for workpiece.	1. Use blade with finer tooth pitch.
	2. Incorrect feed or speed.	2. Reduce/increase feed pressure and/or blade speed.
	3. Gullets loading up with chips.	3. Use blade with a coarse tooth pitch—reduce feed pressure.
Rough cuts	1. Blade teeth too coarse.	1. Use a finer tooth blade.
	2. Blade speed too high.	2. Reduce blade speed.

Wiring Diagram



Replacement Parts

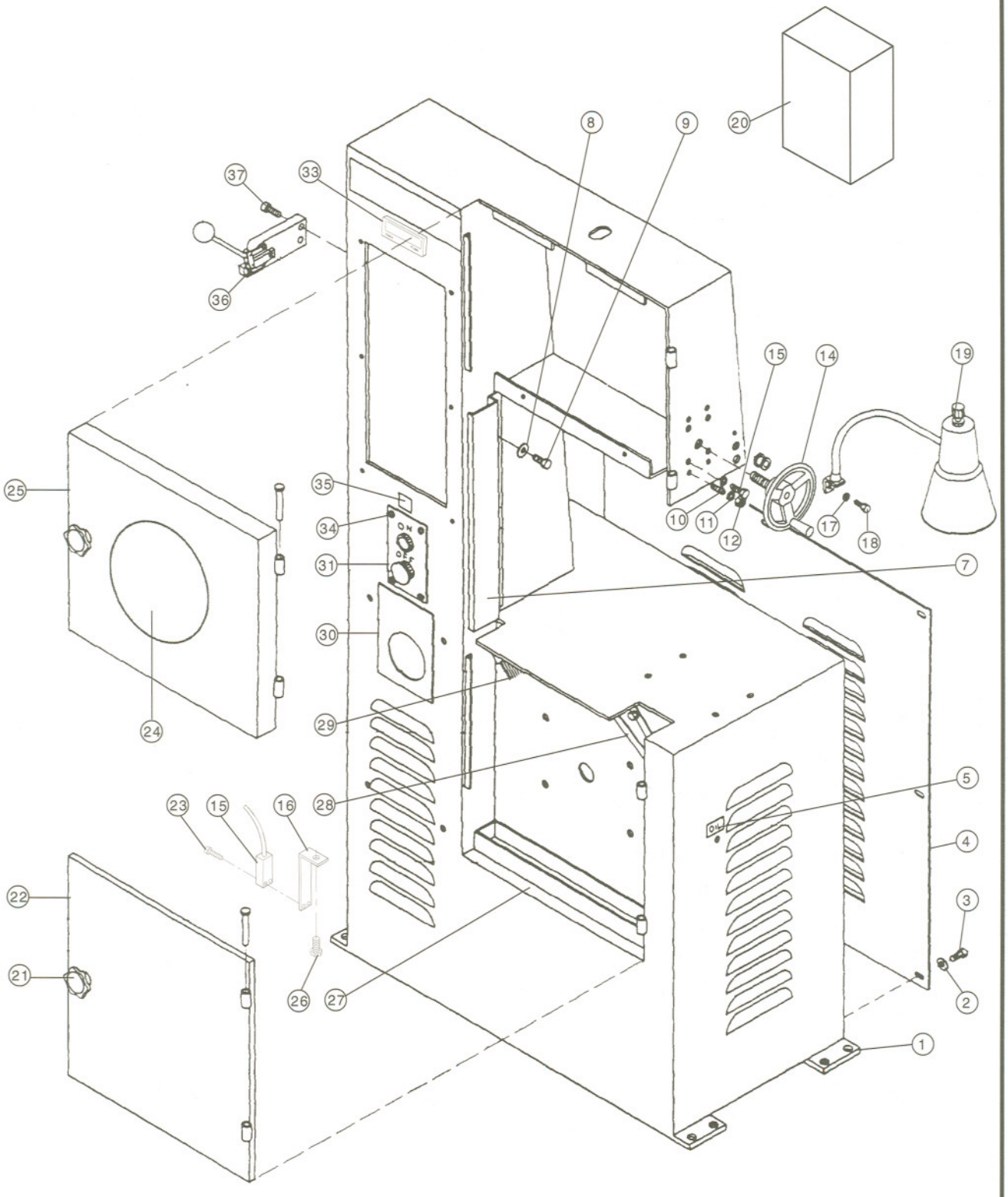
This section provides exploded view illustrations that show the replacement parts for the Model 8014 Verical Band Saw. Also provided are parts listings that provide part number and description. The item numbers shown on the illustration relate the item number in the facing parts listing.

Order replacement parts form:

Wilton Corporation
300 South Hicks Road
Palatine, IL 60067
TEL: 1-888-594-5866
FAX: 1-800-626-9676

Identify the replacement part by the part number shown in the parts listing. Be sure to include the model number and serial number of your machine when ordering replacement parts to assure that you will receive the correct part.

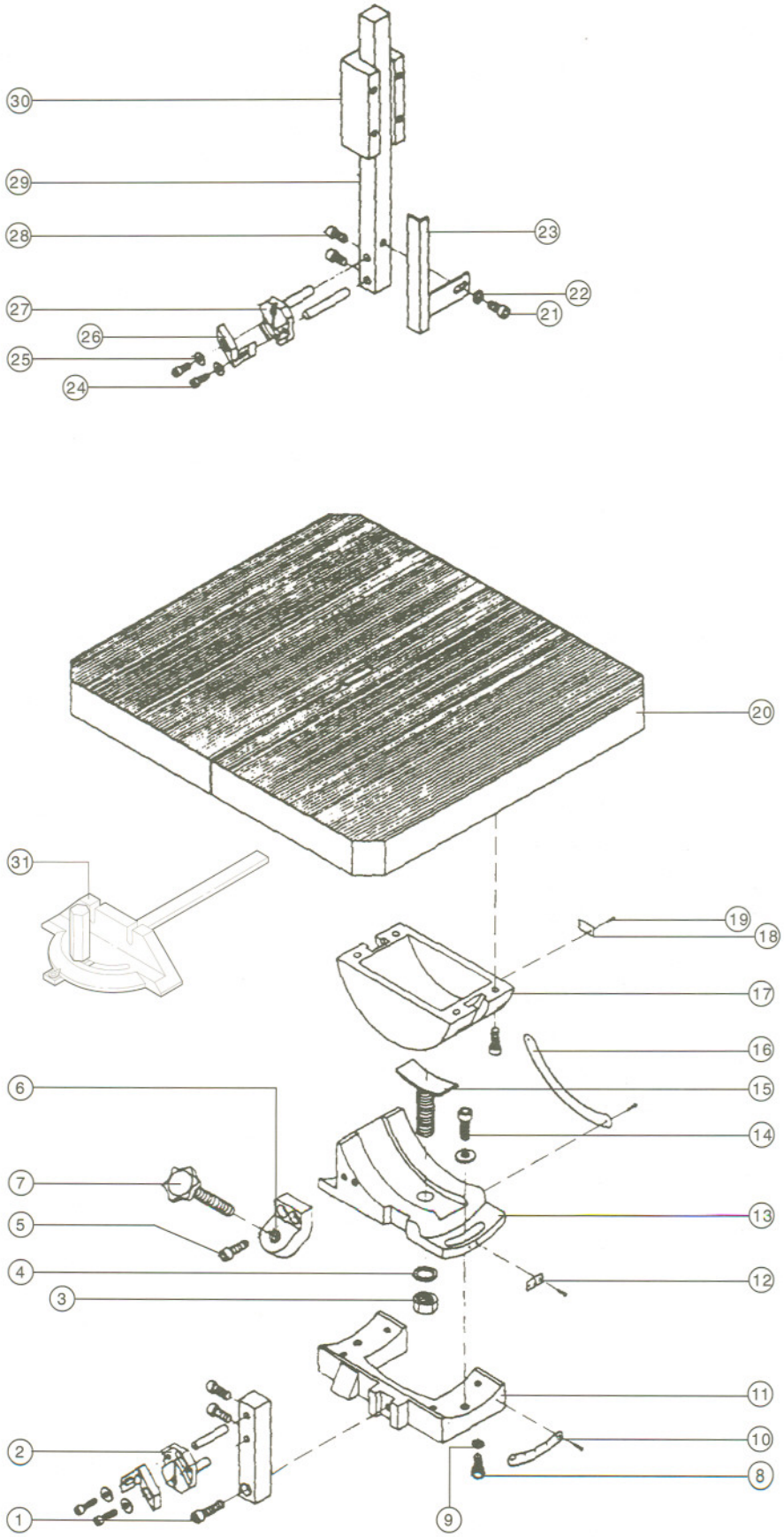
Exploded View - Enclosure



Parts List - Enclosure

Ref.No.	Part Number	Description	Qty
1	5507831	Frame	1
2	5507832	Washer	6
3	5507833	Screw	6
4	5682271	Rear Cover	1
5	5507834	Label, Oil	1
6	- - - - - - -		
7	5682281	Blade Guard	1
8	5507835	Washer	2
9	5507836	Screw	2
10	5507837	Set Screw	1
11	5507838	Washer	1
12	5507839	Nut	1
13	- - - - - - -		
14	5507840	Handwheel	1
15	5515226	Prox. Sensor, SFPM	1
16	5516376	Bracket, Prox. Sensor	1
17	5507841	Washer	1
18	5507842	Screw	1
19	5682261	Lamp	1
20	5507843	Enclosure, Electrical	1
21	5683781	Handle/Lock Assembly,Door	2
22	5683791	Door, Bottom	1
23	5516377	Screw, Cap	1
24	5597844	Feed/Speed Chart	1
25	5507845	Door, Upper	1
26	5516378	Bolt, Hex	1
27	5682221	Chip Pan	1
28	5682241	Channel, Small Chip	1
29	5682211	Brush, Cleaning	1
30	5507846	Label, Speed Change Door Warning	1
31	5682101	Switch, On/Off	1
32	- - - - - - -		
33	5515283	LED Readout, SFPM	1
34	5507847	Screw	4
35	5507848	Label, Blade Direction	1
36	5681392	Blade Cutter Assembly	1
37	5507849	Screw, Socket Head Cap	2

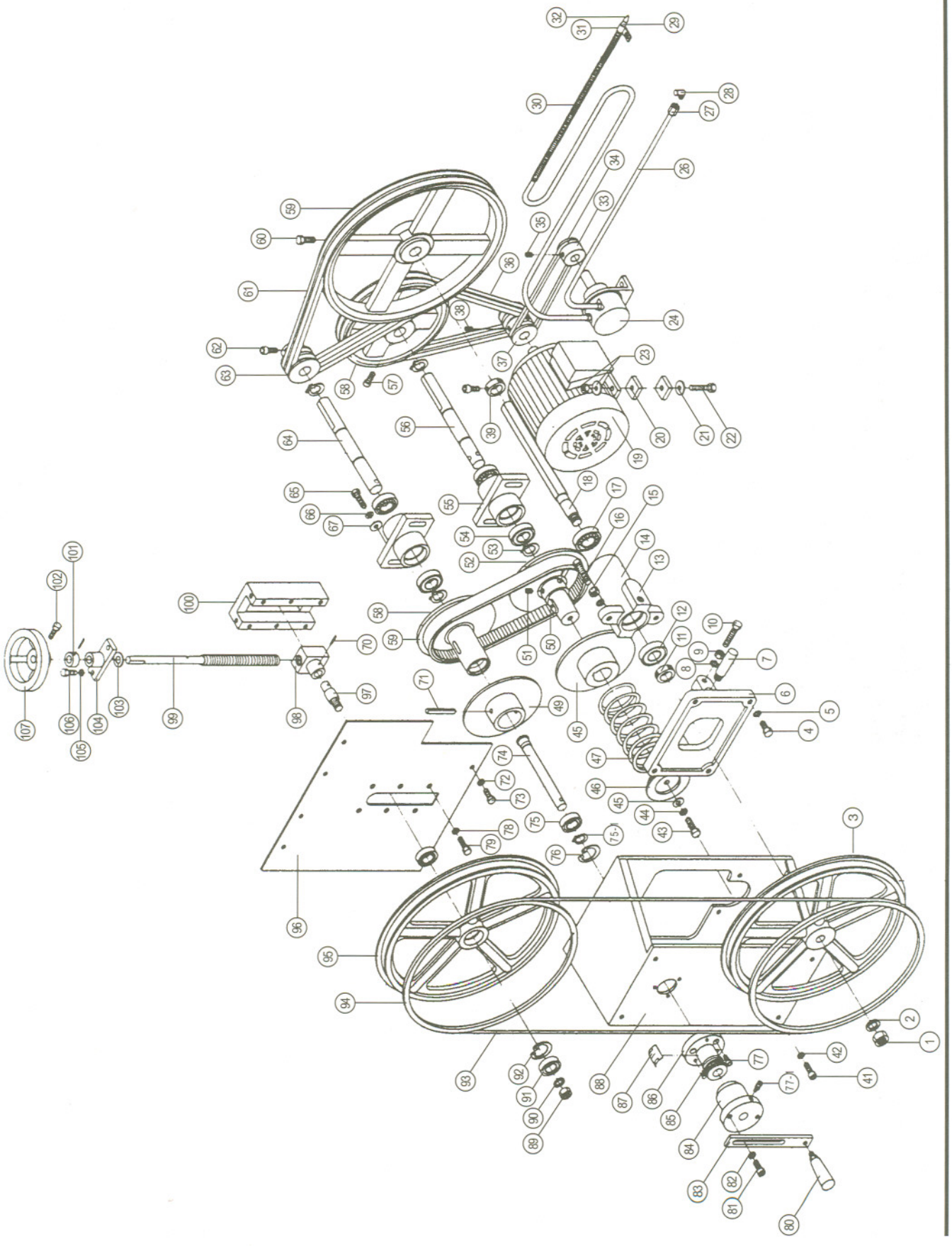
Exploded View - Saw Table



Parts List - Saw Table

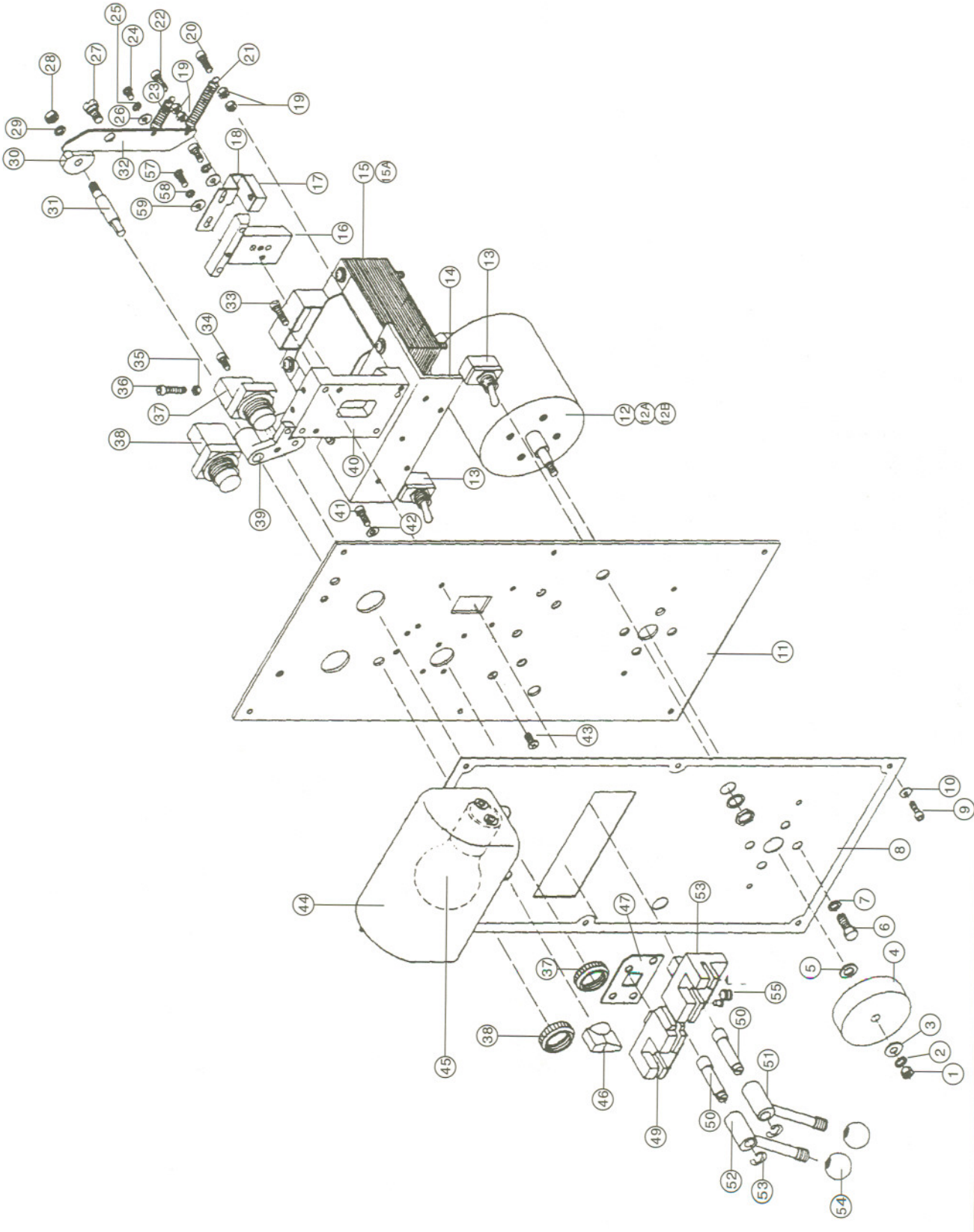
Ref.No.	Part Number	Description	Qty
1	5507850	Screw, Socket Head Cap	2
2	5682811	Guide Seat	1
3	5507851	Nut, Hex	1
4	5507852	Washer	1
5	5507853	Screw, Socket Head Cap	2
6	5682781	Screw Seat, Tilt Adjust	2
7	5682801	Screw, Tilt Adjust	1
8	5507854	Screw, Socket Head Cap	1
9	5507855	Washer	1
10	5682881	Plate, Dial Indicator	1
11	5682871	Seat, Tilting (Front-Back)	1
12	5682861	Indicator	2
13	5682771	Seat, Table	1
14	5597856	Screw, Socket Head Cap	2
15	5682841	Screw, Lock (Left-Right)	1
16	568285	Plate, Dial Indicator (Left-Right)	1
17	5682761	Seat, Tilting	4
18	5507857	Plate, Dial Indicator	1
19	5507858	Rivet	6
20	5682751	Table	1
21	5507859	Screw, Socket Head Cap	1
22	5507860	Washer	1
23	5682921	Guard, Blade	1
24	5507861	Screw, Socket Head Cap	4
25	5507862	Washer	4
26	5682791	Support, Tungsten	4
27	5682811	Seat, Guide	2
28	5597863	Screw, Socket Head Cap	4
29	5682911	Rod, Elevating Guide	1
30	5682901	Seat, Fixed, Guide Rod	1
31	5681811	Gauge, Miter	1

Exploded View - Drive Components



Ref. No.	Part Number	Description	Qty	Ref. No.	Part Number	Description	Qty	Ref. No.	Part Number	Description	Qty
1	5682731	Locknut, Left-Hand Thread	1	39	5682671	Ring, Fixed	1	76	5680381	Ring, Lock	1
2	5507864	Washer	1	41	5507884	Screw, Socket Head Cap	4	77	5507899	Screw, Socket Head Cap	3
3	5682741	Wheel, Lower	1	42	5507885	Washer	1	77-1	5507800	Set Screw, Dog Point	1
4	5507865	Screw, Hex Head	4	43	5682381	Bolt, Fixed	1	78	5507901	Washer, Lock	1
5	5507866	Washer	4	44	5507886	Washer, Lock	1	79	5507902	Screw, Socket Head Cap	6
6	5682721	Bearing, Bracket Fixed	1	45	5507887	Washer, Flat	1	80	5682471	Handle, Plastic	6
7	5682711	Pin, Fixed	2	46	5682391	Plate, Spring Guard	1	81	5507903	Screw, Socket Head Cap	2
8	5507867	Washer	1	47	5682401	Spring	1	82	5507904	Washer	1
9	5507868	Nut, Hex	1	48	5682411	Pulley, Stepless (Right)	1	83	5682481	Handle, Adjustment	1
10	5507869	Screw, Hex Head	1	49	5682521	Pulley, Stepless Adj. (Right)	1	84	5680471	Handwheel, Adjustment	1
11	5507870	Spacer	1	50	5507888	Key	2	85	5507905	Set Screw	1
12	9100321	Bearing	1	51	5587889	Set Screw	1	86	5680481	Seat, Adjustment	1
13	5682701	Seat, Bearing	1	52	5682421	Pulley, Stepless (Left)	1			Handwheel	
14	5507867	Washer	2	53	5680381	Ring, Locking	4	87	5507906	Label, Speed	1
15	5597868	Nut, Hex	2	54	5680391	Bearing	4	88	5682301	Box, Stepless Variable	1
16	5597869	Screw, Hex Head	2	55	5682441	Seat, Bearing	1			Speed	
17	9100321	Bearing	2	56	5682451	Shaft, Stepless (Spring)	1	89	5682611	Nut, Lock	1
18	5682691	Shaft, Lower Wheel	1	57	5587890	Screw, Hex Head	1	90	5507907	Washer, Lock	1
19	5682331	Motor, 1 HP, Single-Phase	1	58	5682321	Pulley	1	91	5507908	Bearing	2
20	5507861	Spacer	8	59	5682351	Pulley, Lower Wheel	1	92	5507909	Ring, Snap	1
21	5507872	Washer	8	60	5587890	Screw, Hex Head	1	93	9108381	Blade	1
22	5507873	Screw, Hex Head	4	61	5507891	V-Belt (A55)	1			(1/2 x 0.025 x 110 in. Long)	
23	5507874	Nut, Hex	4	62	5507882	Set Screw	1	94	5682591	Ring, Rubber	2
24	5682361	Pump, Air	1	63	5682311	Pulley, Stepless (Adjustable)	2	95	5682601	Wheel, Upper	1
25	-------			64	5682561	Shaft, Stepless (Adjustable)	1	96	5507910	Mounting Plate,	1
26	5507875	Line, Oil	11	65	5507893	Screw, Hex Head	2			Upper Wheel	
27	5507876	Connector	1	66	5507894	Washer, Lock	2	97	5507911	Shaft	1
28	5507877	Cup, Oil	1	67	5507895	Washer, Flat	2	98	5682651	Nut, Lead Screw	1
29	5507878	Hose, Air	1	68	5682541	Pulley, Stepless Adj. (Left)	1	99	5682641	Lead Screw	1
30	5507879	Spring, Protection	1	69	5682531	Belt (775VB 25/30)	1	100	5682631	Way, Lead Screw Nut	1
31	5597880	Clamp, Hose	1	70	5507896	Pin, Roll	1	101	5507912	Pin, Spring	1
32	5597881	Nozzle, Air	1	71	5680521	Pin, Spring	1	102	5507913	Screw, Socket Head Cap	1
33	5682371	Pulley, Air Pump	1	72	5507897	Washer	5	103	5507914	Washer	1
34	5683361	V-Belt (M21)	1	73	5507898	Screw	5	104	5682621	Fixed Piece	1
35	5507882	Set Screw	1	74	5682511	Shaft, Stepless Adjustment	1	105	5507915	Washer	4
36	5507883	V-Belt (A40)	1	75	9100331	Bearing	1	106	5507916	Screw, Hex Head	4
37	5682341	Pulley, Motor	1	75-1	5680501	Ring, Lock	1	107	5682581	Handwheel	1
38	5507882	Set Screw	1	76	5680381	Ring, Lock	1				

Exploded View - Welder



Ref. No.	Part Number	Description	Qty	Ref. No.	Part Number	Description	Qty
1	5507917	Nut, Hex	1	32	5683331	Plate, Pressure Cross	1
2	5507918	Washer, Lock	1	33	5507937	Screw	4
3	5507919	Washer, Flat	1	34	5507938	Screw	1
4	5683151	Wheel, Grinding	1	35	5507939	Washer	1
5	5507920	Spacer	1	36	5507940	Screw	1
6	5507921	Screw	4	37	5507941	Button, Weld	1
7	5507922	Washer	4	38	5507942	Button, Anneal	1
8	5683031	Name Plate	1	39	5683171	Support, Cam Shaft	1
9	5507923	Screw, Socket Head Cap	6	40	5683271	Pad, A Sliding	1
10	5507924	Washer, Flat	6	41	5507943	Screw	4
11	5683241	Panel, Welding	1	42	5507944	Washer	4
12	5681711	Motor, Grinder (115 Volts)	1	43	5507945	Screw, Flat Head	5
12A	5681711A	Motor, Grinder (220 Volts)	1	44	5683081	Cover, Working Lamp	1
12B	5681711B	Motor, Grinder (440 Volts)	1	45	5683091	Lamp	1
13	5683281	Switch, On/Off	1	46	5683111	Knob, Clamp Pressure	1
14	5507925	Bracket, Transformer	2	47	5683121	Plate, B Insulating	1
15	5681631C	Transformer (220 V/2 KVA)	1	48	5683041	Base, A Welding	1
15A	5681631D	Transformer (440 V/2 KVA)	1	49	5683001	Base, B Welding	1
16	5683251	Block, Sliding	1	50	5683141	Shaft, Centerless Handle	2
17	5683191	Switch, Microwave	1	51	5683071	Handle, A Centerless	1
18	5683181	Base, Limit Switch	1	52	5683011	Handle, B Centerless	1
19	5507926	Nut, Hex	2	53	5683131	Ring, C Lock	2
20	5507927	Screw	1	54	5683021	Knob, Handle	2
21	5683261	Spring	1	55	5507946	Screw, Set	2
22	5507928	Screw	1	56	5507950	Screw	1
23	5683261	Spring	1	57	5507951	Screw	1
24	5507929	Screw	1	58	5507952	Washer, Lock	2
25	5507930	Washer, Lock	1	59	5507953	Washer, Flat	2
26	5507931	Washer, Flat	1	*	5507529	Relay	1
27	5683321	Screw, Pressure Cross	1	*	5507947	Transformer, Control	1
28	5508413	Nut	1	*	5597948	Strip, Terminal	1
29	5507935	Washer	1	*	5507954	Guard, Grinding Wheel	1
30	568331	Cam, Pressure	1				
31	5507936	Shaft	1	* Noted items not illustrated.			

Notes: